



DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	C DIA MIN	L	L1 REF	M	P REF	W HEX	X REF	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.352 .348	.173 .169	.164	.405 .385	.230	.040 .020	.250	.220 .212	.095	2,300	30-40
6	3/16	.1900-32 UNJF-3B	.388 .384	.212 .208	.188	.415 .395	.240	.040 .020	.285	.251 .243	.095	2,750	40-50
8	1/4	.2500-28 UNJF-3B	.509 .505	.276 .272	.248	.485 .465	.280	.055 .035	.355	.313 .305	.100	5,000	105-130
10	5/16	.3125-24 UNJF-3B	.636 .630	.340 .334	.310	.565 .545	.325	.055 .035	.430	.376 .367	.105	8,300	200-250
12	3/8	.3750-24 UNJF-3B	.720 .714	.403 .397	.372	.635 .615	.365	.055 .035	.500	.439 .430	.105	12,700	340-420
14	7/16	.4375-20 UNJF-3B	.861 .855	.468 .462	.435	.790 .770	.420	.060 .040	.557	.503 .488	.110	19,000	525-600

**NOTES:**

- Go thread gage penetration shall be 3/4 of one revolution minimum.
- Dimensions are in inches and apply after finish and before application of lubricants.
- "C" diameter is the inner diameter of the Teflon insert.
- Burrs from cutoff process and cutting torque-off groove allowed.
- Use the following test bolts for thread lock inspection:  
 TB64VF( )L for HST1385DU( ), and HST1385HK( ).  
 TB64AP( )L for HST1385UK( ).

**MATERIAL:** Collar 302HQ (or 18-9LW) stainless steel per ASTM A-493, Type XM-7;  
 305 stainless steel per AMS-QQ-S-763 and AMS5686; or 303 Se stainless steel  
 per ASTM A-582 (AMS5640).  
 Insert Teflon per ASTM D1710, Type I, Grade 1.

**FINISH:** Collar HST1385PB( ) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and  
 cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1385DU( ) = Collar only with solid film lube per AS5272, Type I.  
 HST1385UK( ) = Collar only with HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with green  
 identification on body of collar, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1385HK( ) = Collar only with HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.  
 Insert None.

**SPECIFICATION:** HI-LITE™ Product Specification No. 381. Test bolt requirement exceptinos per note [5] above.

**CODE:** Dash number indicates nominal thread size in 1/32nds.  
 See Finish note for explanation of code letters.

**EXAMPLE:** HST1385PB8 = 1/4-28 HI-LITE™ sealing collar with Type II cadmium plate and teflon insert.

"HI-LITE" AND "HST" ARE INTERNATIONAL  
 REGISTERED TRADEMARKS OF HI-SHEAR CORPORATION

			TITLE	DRAWING NO.
			<b>HI-LITE™ COLLAR</b>	<b>HST1385</b>
			(SEALING TYPE)	
			STAINLESS STEEL WITH TEFLON INSERT	
			1/16 GRIP VARIATION, TENSION APPLICATION	
			FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	1 of 1
DATE	BY			
DRAWN	1983-07-29	DPS		
APPROVED	1983-07-29	R.TING		
REVISION	2019-04-04	F.CARINGELLA		